

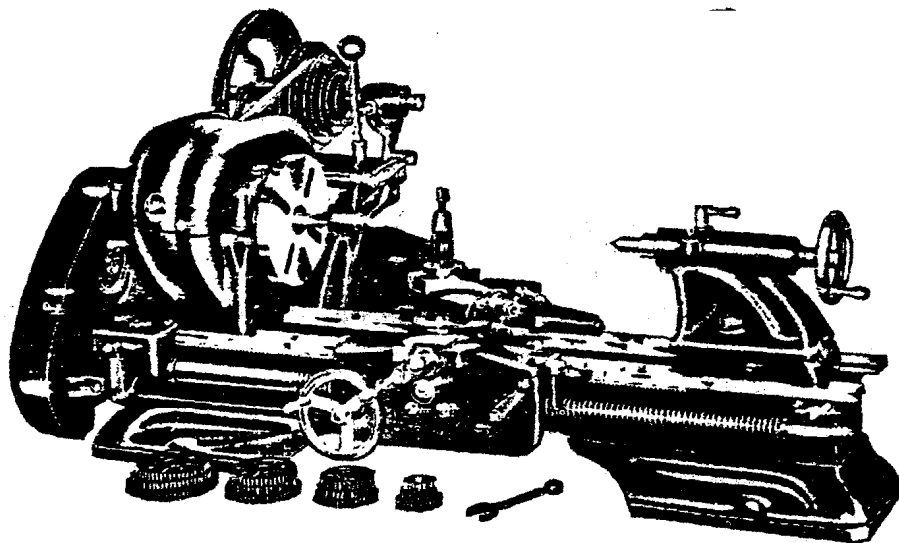
Atlas

PARTS LIST FOR 10"-F SERIES ATLAS LATHES

FOR ATLAS TIMKEN BEARING LATHES:
WITH HORIZONTAL COUNTERSHAFT—Cat. Nos.: TH36, TH42, TH48, TH54
WITH VERTICAL COUNTERSHAFT—Cat. Nos.: TV36, TV42, TV48, TV54

FOR ATLAS BABBITT BEARING LATHES:
WITH HORIZONTAL COUNTERSHAFT—Cat. Nos.: H36, H42, H48, H54
WITH VERTICAL COUNTERSHAFT—Cat. Nos.: V36, V42, V48, V54

FOR ATLAS QUICK-CHANGE LATHES:
Cat. Nos.: QC42 and QC54



ATLAS PRESS CO. • Kalamazoo, Mich., U.S.A. 49007

SINCE 1911, MANUFACTURERS OF PRECISION MACHINE TOOLS

ORDERING INFORMATION

IMPORTANT: The following information must be furnished on all repair part orders.

1. Quantity Required
2. PART NUMBER and Name of Part
3. Model and Serial Number of Lathe

PURCHASE ORDER
JONES MACHINERY CO.
 CANTON, TEXAS

ORDER NO. 40356

ATLAS PRESS CO.
 KALAMAZOO 130. MICH.

QUANTITY	DESCRIPTION	PRICE
1	9-8 RAM	
2	10F-19 NUT FOR 10" LATHE TH54 036703	

Sample For Ordering
Parts By Mail

TELEGRAM

ATLAS PRESS CO.
 KALAMAZOO 130. MICH.

PLEASE SHIP ONE 9-8 RAM TWO
 10F-19 NUT FOR 10" LATHE
 TH54 036703

By Telegram

Be sure to give MODEL and SERIAL number shown on plate, located at tailstock end of lathe bed.

NOTE: On Lathes without this plate, MODEL and SERIAL Number is found on top of FRONT BED-WAY.

Atlas

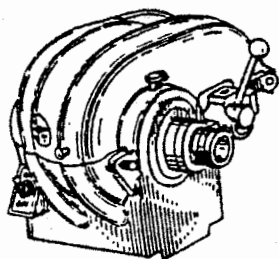
MODEL NUMBER TH54 SERIAL NUMBER 036703

Parts shown without part numbers are standard parts and should be purchased locally.
 We reserve the right to make changes in design and specifications without notice.

INDEX FOR LATHE PARTS AND PRICES

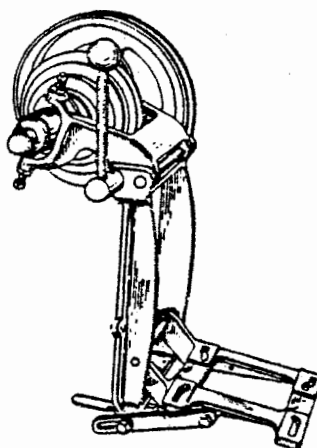
	Page
Unit Assemblies	3
Babbitt Bearing Headstock	4
Timken Bearing Headstock	5
Carriage and Compound	6
Lead Screw and Feed Gears	7
Countershaft	8
Tailstock, Bed and Rack	9
Quick Changes	10 & 11

Atlas 10" F-SERIES LATHE UNIT ASSEMBLIES

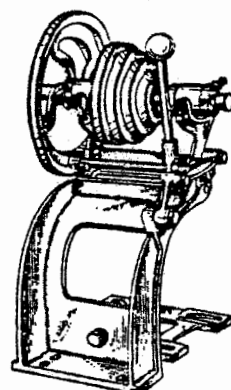


10A-28XH TIMKEN BEARING HEADSTOCK ASSEMBLY
For Horizontal Countershaft Lathes

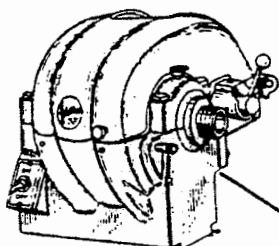
10A-28XV TIMKEN BEARING HEADSTOCK ASSEMBLY
For Vertical Countershaft Lathes



9-20X VERTICAL COUNTERSHAFT ASSEMBLY

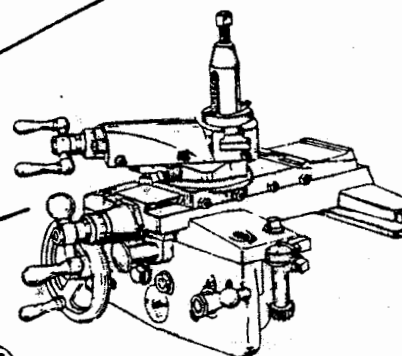


10-20X HORIZONTAL COUNTERSHAFT ASSEMBLY

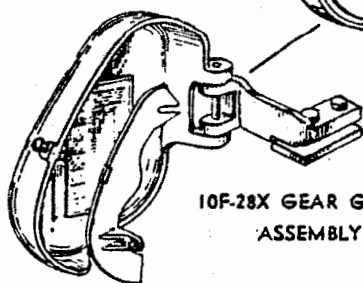


10A-28BXH TIMKEN BEARING HEADSTOCK ASSEMBLY
For Horizontal Countershaft Lathes
Replaces 10D-28BXH Babbitt Bearing Headstock Assembly

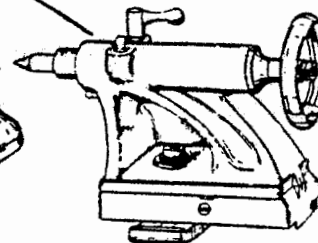
10A-28XV TIMKEN BEARING HEADSTOCK ASSEMBLY
For Vertical Countershaft Lathes
Replaces 10D-28XV Babbitt Bearing Headstock Assembly



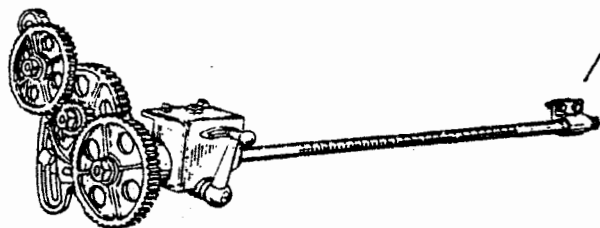
10F-9XY CARRIAGE ASSEMBLY



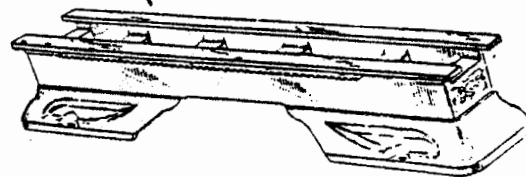
10F-28X GEAR GUARD ASSEMBLY



10D-5X TAILSTOCK ASSEMBLY



LEAD SCREW AND FEED GEAR ASSEMBLY



BED, LEGS AND RACK ASSEMBLY

10F-35-36X 36" MODEL LATHE
10F-35-42X 42" MODEL LATHE
10F-35-48X 48" MODEL LATHE
10F-35-54X 54" MODEL LATHE

9-1 BX 36" MODEL LATHE Not Available
942BX 42" MODEL LATHE
948BX 48" MODEL LATHE Not Available
954BX 54" MODEL LATHE

BABBITT BEARING HEADSTOCK REPLACEMENT PARTS

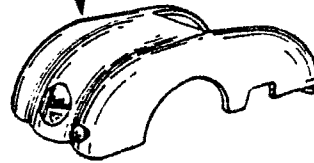


Not Available
10D-246
GEAR GUARD (RIGHT)
FOR VERTICAL CTRSHAFT
LATHES ONLY

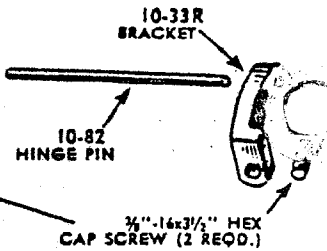


Not Available
10D-247
GEAR GUARD (LEFT)
FOR VERTICAL CTRSHAFT
LATHES ONLY

10-18
GEAR GUARD
FOR HORIZONTAL CTRSHAFT
LATHES ONLY

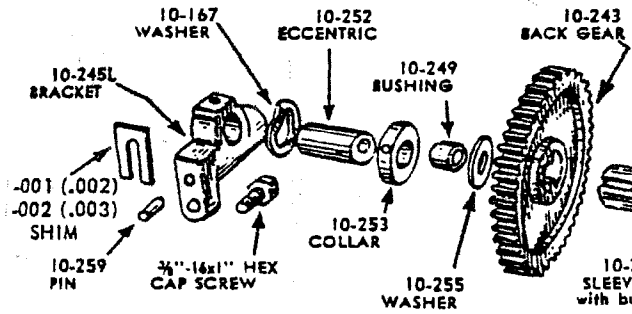


10-33L
BRACKET

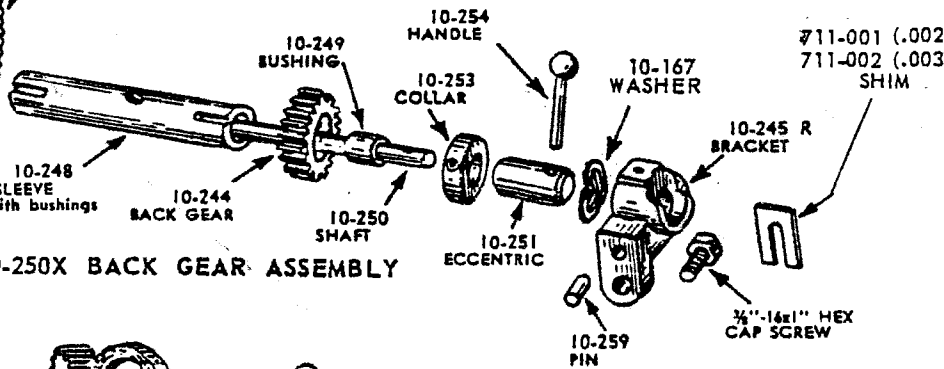


10-82
HINGE PIN

3/8"-16x3 1/2" HEX
CAP SCREW (2 REQD.)



10-250X BACK GEAR ASSEMBLY

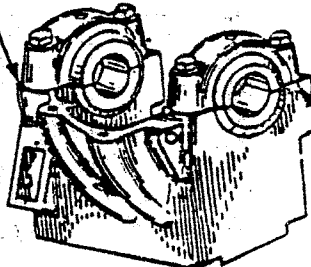


711-001 (.002)
711-002 (.003)
SHIM

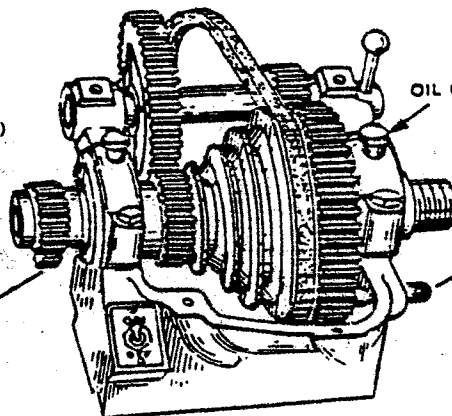
10-245 R
BRACKET

3/8"-16x1" HEX
CAP SCREW

9-128
SHIM (2 REQD.)

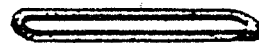


10D-128
SHIM (2 REQD.)



9-204
OIL CUP (2 REQD.)

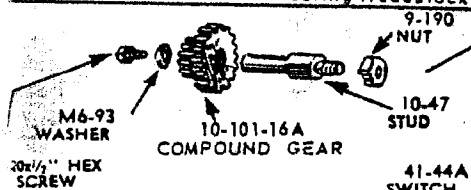
10-42A
INDEX PIN



S10-21
SPINDLE BELT (Horizontal
Ctrshaft)

9-126
SPINDLE BELT (Vertical
Ctrshaft)

10D-2BA TIMKEN BEARING HEADSTOCK
Replaces 10D-2BA Babbitt Bearing Headstock

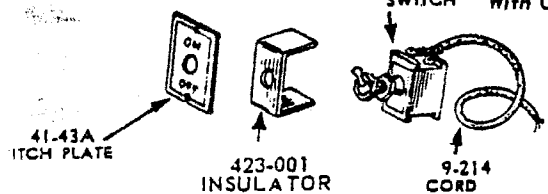


10A-2BXH HEADSTOCK ASSEMBLY

With Gear Guard - for Horizontal Countershaft Lathe
Replaces 10D-2BXH

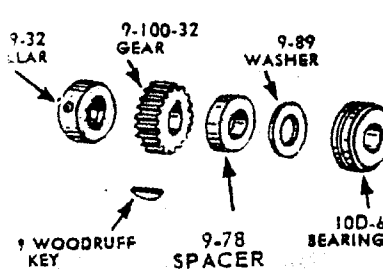
10A-2BXY HEADSTOCK ASSEMBLY

for Vertical Countershaft Lathe
Replaces 10D-2BXY



9-214
CORD

423-001
INSULATOR

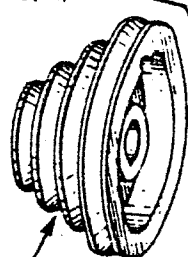


10-258
BUSHING (3 REQD.)



10-242
BACK GEAR WITH
BUSHING

990-359
PULLEY & BUSHING



10-241
BACK GEAR

No. 15 WOODRUFF
KEY



9-15
6" FACE PLATE

9-97
CLAMP

10-262
WASHER

1/2"-13x1 1/2" HEX
CAP SCREW

10-256
PIN

9-60
PLUNGER

9-61
SPRING

10-31
SPINDLE

138
SLEEVE

9-88
CENTER

Replacement babbitt bearings
not available. Order X10D-2BA
conversion unit - includes
headstock, spindle, Timken
bearings, bearing shields and
thrust collar.

10-31X SPINDLE ASSEMBLY

TIMKEN BEARING HEADSTOCK PARTS

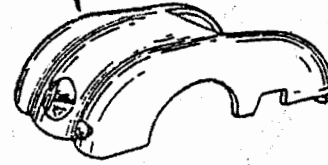


NOT AVAILABLE
10D-246
GEAR GUARD (RIGHT)
FOR VERTICAL CTRSHAFT
LATHES ONLY



NOT AVAILABLE
10D-247
GEAR GUARD (LEFT)
FOR VERTICAL CTRSHAFT
LATHES ONLY

10-18
GEAR GUARD
FOR HORIZONTAL CTRSHAFT
LATHES ONLY

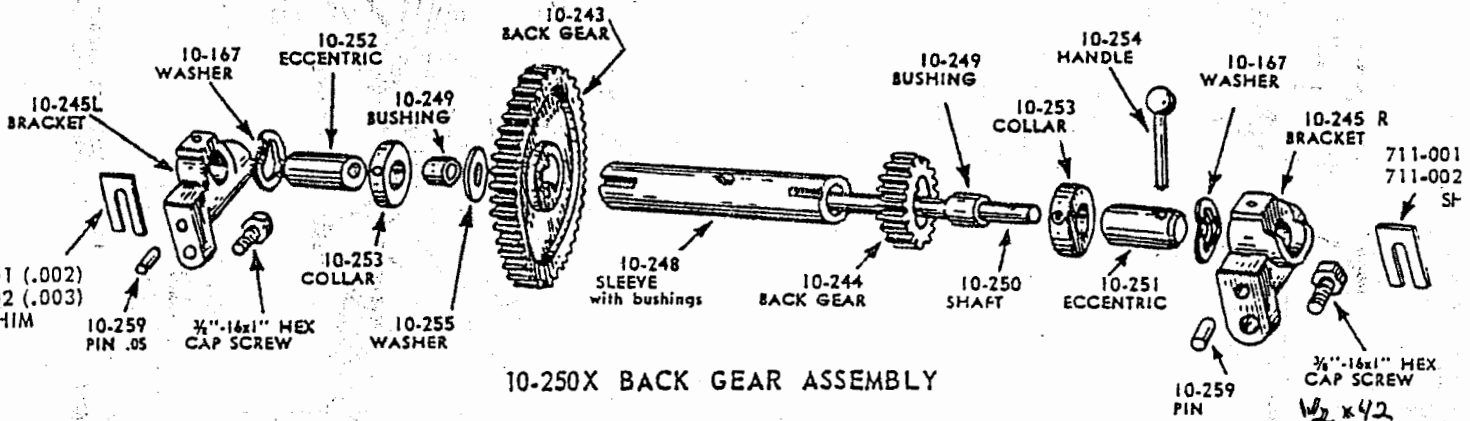


10-33L
BRACKET

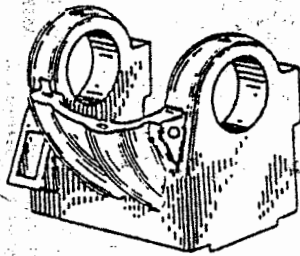
10-33R
BRACKET

10-82
HINGE PIN

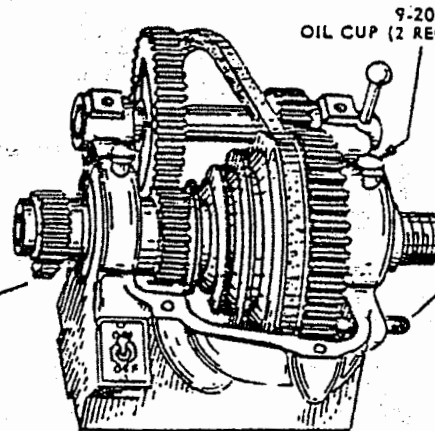
$\frac{3}{8}$ "-16x $\frac{3}{4}$ " HEX
CAP SCREW (2 REQD.)



10-250X BACK GEAR ASSEMBLY

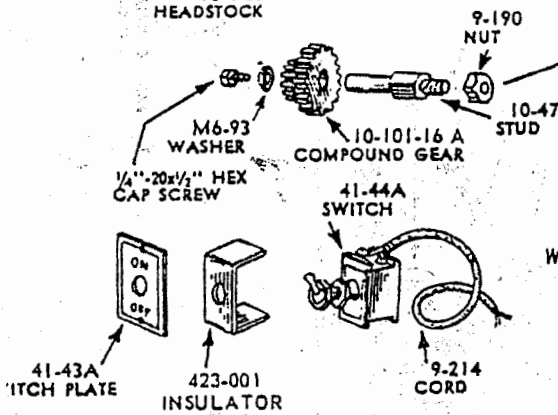


10A-28
HEADSTOCK



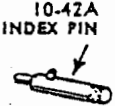
10A-2BXH HEADSTOCK ASSEMBLY
With Gear Guard - for Horizontal Countershaft Lathe

10A-2BXV HEADSTOCK ASSEMBLY
for Vertical Countershaft Lathe



10-31TX SPINDLE ASSEMBLY

9-204
OIL CUP (2 REQD.) .25 ea.



10-42A
INDEX PIN

S10-21
SPINDLE BELT (Hor
Ctrshaft)
9-126
SPINDLE BELT (Ver
Ctrshaft)

9-210
BALL

9-61
SPRING

9-15
6" FACE PLATE

9-97
CLAMP

10-262
WASHER

$\frac{1}{2}$ "-13x $\frac{1}{4}$ " HEX
CAP SCREW

10-256
PIN

9-6
SPRING

10A-9C
BEARING

9-88
CENTER

10-31TX
SPINDLE ASSEMBLY

10A-7
BAFFLE

9-60
PLUNGER

10-258
BUSHING (3 REQD.)

10-241
BACK GEAR

10A-89
COLLAR

10A-11C
BEARING

10A-8
BAFFLE

10A-6
SPACER

9-32
COLLAR

9-100-32
SPINDLE GEAR

41-43A
SWITCH PLATE

423-001
INSULATOR

9-214
CORD

41-44A
SWITCH

10-101-16 A
COMPOUND GEAR

10-47
STUD

9-190
NUT

10A-28
HEADSTOCK

10-245L
BRACKET

1-001 (.002)
SHIM

1-002 (.003)
SHIM

10-259
PIN .05

$\frac{3}{8}$ "-16x1" HEX
CAP SCREW

10-253
COLLAR

10-251
ECCENTRIC

10-250
SHAFT

10-244
BACK GEAR

10-248
SLEEVE with bushings

10-249
BUSHING

10-254
HANDLE

10-253
COLLAR

10-251
ECCENTRIC

10-250
SHAFT

10-244
BACK GEAR

10-248
SLEEVE with bushings

10-249
BUSHING

10-254
HANDLE

10-253
COLLAR

10-251
ECCENTRIC

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SLEEVE with bushings

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BUSHING

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BACK GEAR

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SHAFT

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COLLAR

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BUSHING

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BACK GEAR

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SLEEVE with bushings

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BUSHING

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COLLAR

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ECCENTRIC

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10-244
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ECCENTRIC

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10-251
ECCENTRIC

10-250
SHAFT

10-244
BACK GEAR

10-248
SLEEVE with bushings

10-249
BUSHING

10-254
HANDLE

10-253
COLLAR

10-251
ECCENTRIC

10-250
SHAFT

10-244
BACK GEAR

10-248
SLEEVE with bushings

10-249
BUSHING

10-254
HANDLE

10-253
COLLAR

10-251
ECCENTRIC

10-250
SHAFT

10-244
BACK GEAR

10-248
SLEEVE with bushings

10-249
BUSHING

10-254
HANDLE

10-253
COLLAR

10-251
ECCENTRIC

10-250
SHAFT

10-244
BACK GEAR

10-248
SLEEVE with bushings

10-249
BUSHING

10-254
HANDLE

10-253
COLLAR

10-251
ECCENTRIC

10-250
SHAFT

10-244
BACK GEAR

10-248
SLEEVE with bushings

10-249
BUSHING

10-254
HANDLE

10-253
COLLAR

10-251
ECCENTRIC

10-250
SHAFT

10-244
BACK GEAR

10-248
SLEEVE with bushings

10-249
BUSHING

10-254
HANDLE

10-253
COLLAR

10-251
ECCENTRIC

10-250
SHAFT

10-244
BACK GEAR

10-248
SLEEVE with bushings

10-249
BUSHING

10-254
HANDLE

10-253
COLLAR

10-251
ECCENTRIC

9-148 SCREW

9-41 ROCKER

9-39 TOOL POST

9-115 WRENCH

9-40 WASHER

9-136A ANCHOR

9-137A STUD

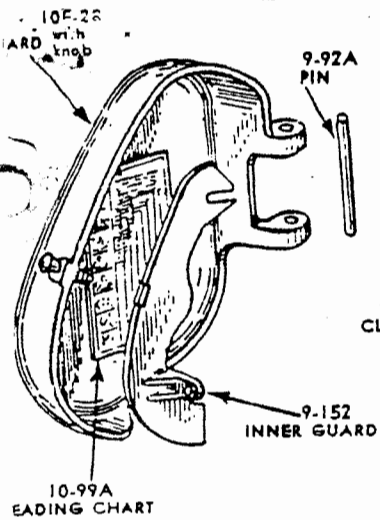
9-39X TOOL POST ASSEMBLY
LESS WRENCH

9-11
Crown Case For 5/8 Lead S&W's

[illegible]

10-301X COMPOUND REST ASSEMBLY

LEAD SCREW AND FEED GEAR PARTS



OF-28X GEAR GUARD ASSEMBLY

3/4"-16x1 1/2" HEX CAP SCREW (2 REQD.)

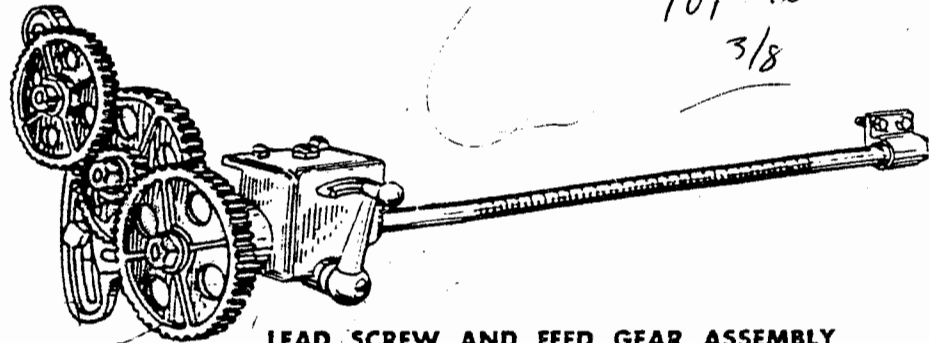
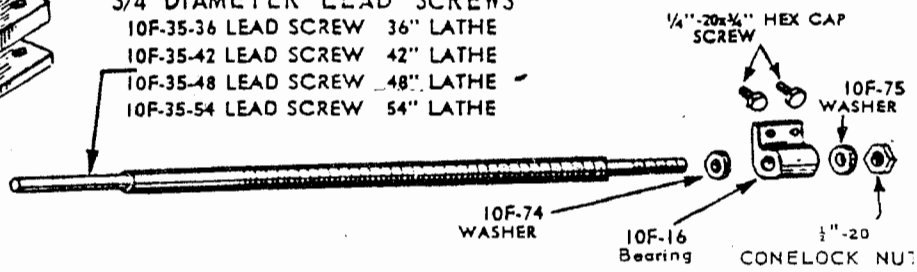
3/4" DIAMETER LEAD SCREWS

10F-35-36 LEAD SCREW 36" LATHE

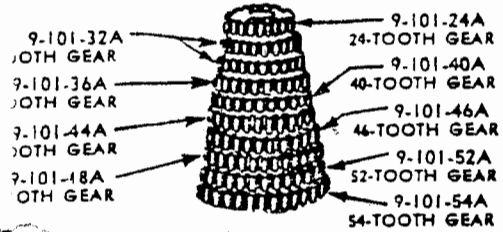
10F-35-42 LEAD SCREW 42" LATHE

10F-35-48 LEAD SCREW 48" LATHE

10F-35-54 LEAD SCREW 54" LATHE



LEAD SCREW AND FEED GEAR ASSEMBLY



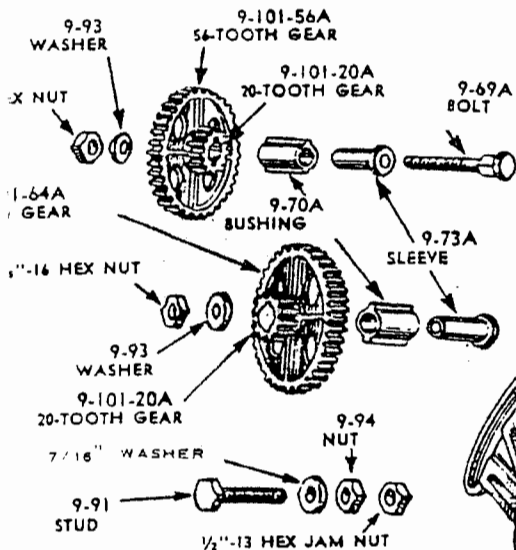
10-25X CHANGE GEAR ASSEMBLY

10F-35-36X 36" MODEL LATHE

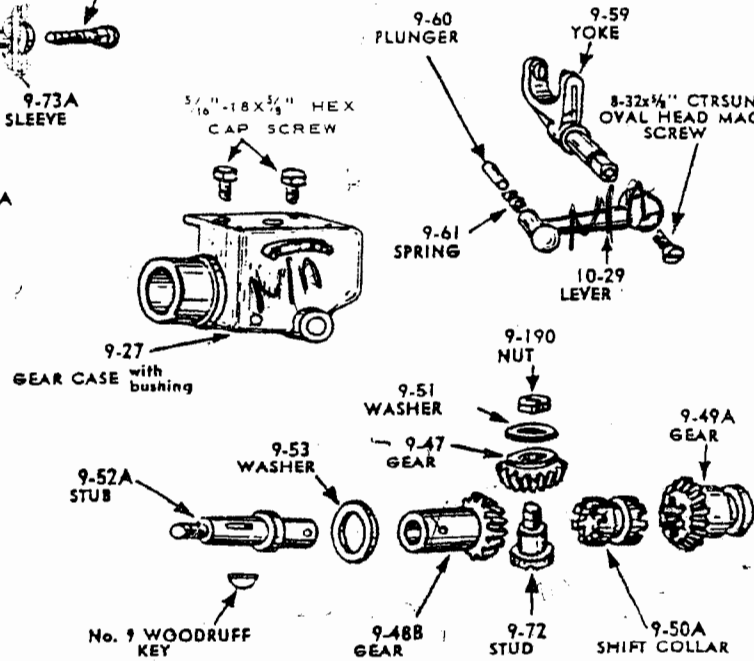
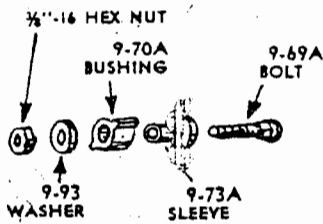
10F-35-42X 42" MODEL LATHE

10F-35-48X 48" MODEL LATHE

10F-35-54X 54" MODEL LATHE

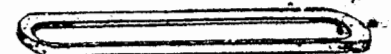
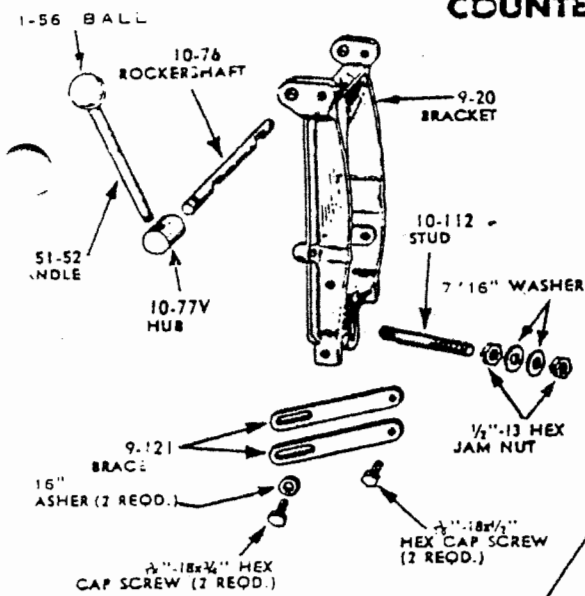


10-25X CHANGE GEAR BRACKET ASSEMBLY

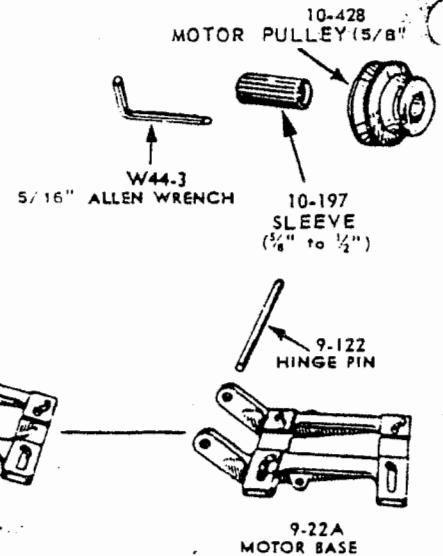


9-27X REVERSE GEAR CASE ASSEMBLY

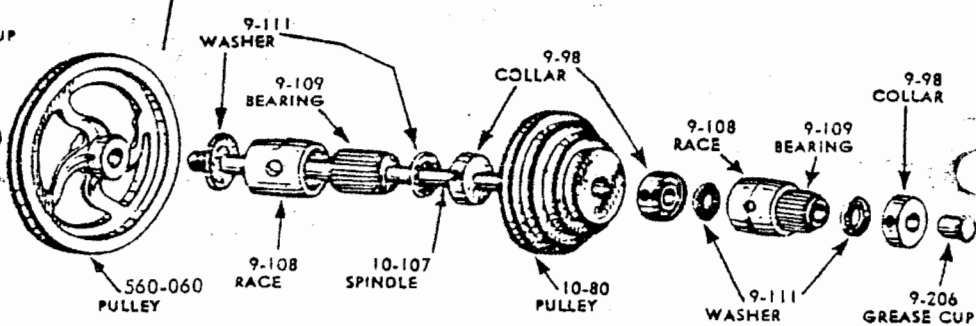
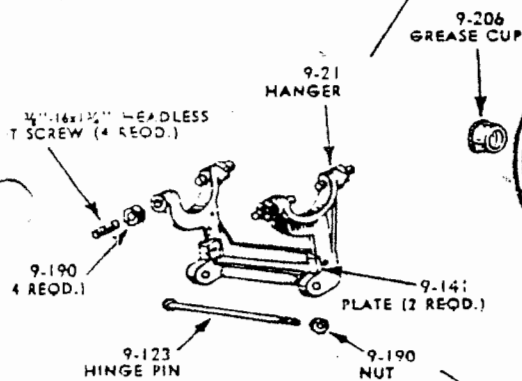
COUNTERSHAFT PARTS



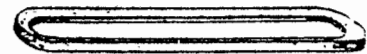
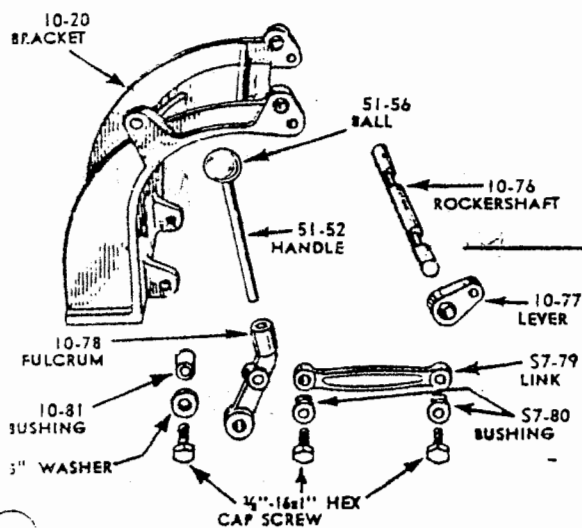
BD 3M-34
MOTOR-TO-CTRSHAFT BELT



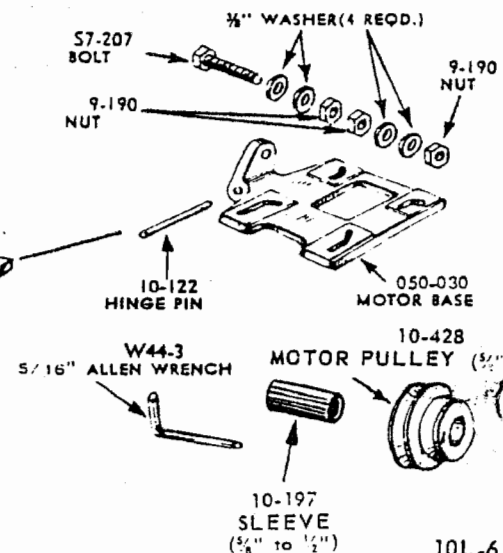
9-20X VERTICAL
COUNTERSHAFT ASSEMBLY
WITH MOTOR BELT AND PULLEY



10-107X COUNTERSHAFT SPINDLE ASSEMBLY

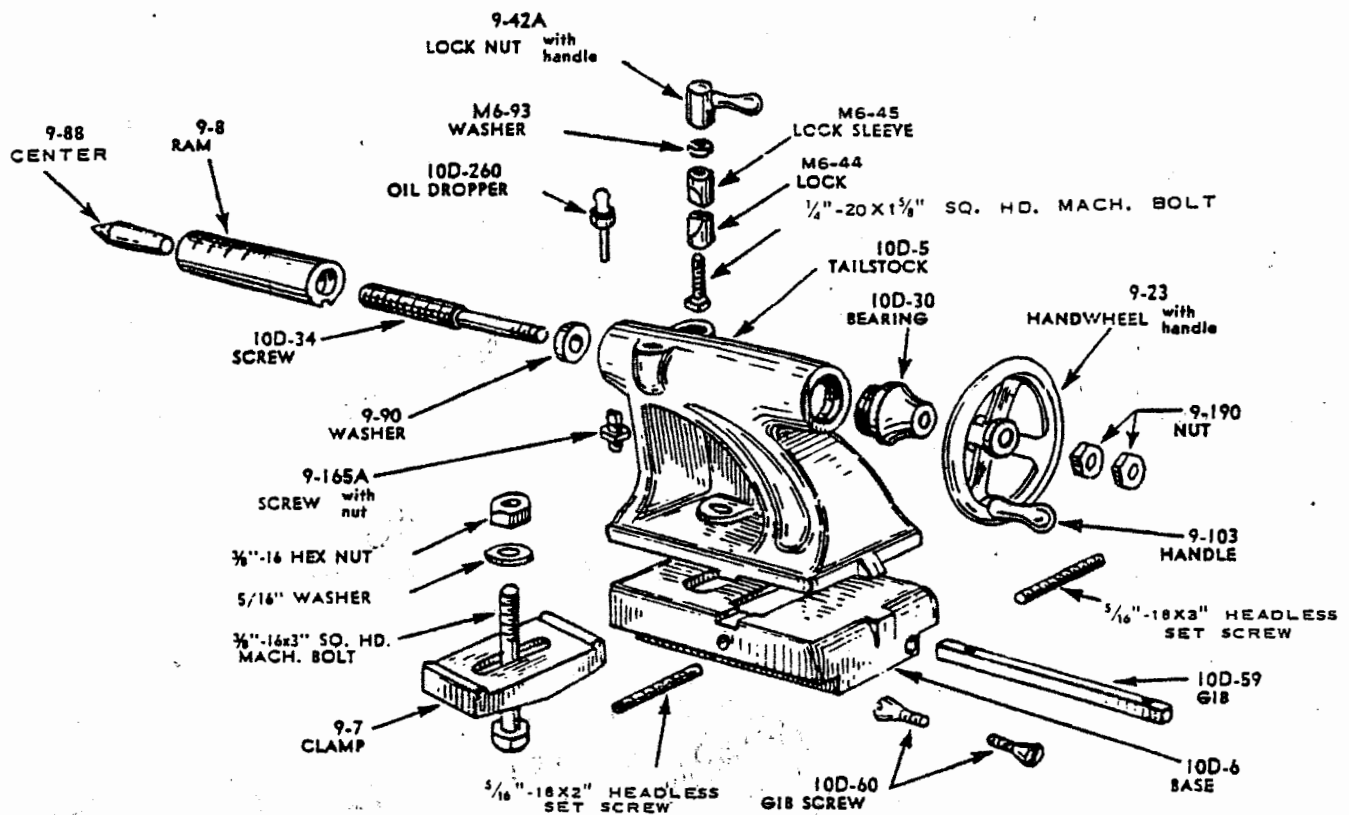


BD2M-34
MOTOR-TO-CTRSHAFT BELT



10-20X HORIZONTAL
COUNTERSHAFT ASSEMBLY
WITH MOTOR BELT AND PULLEY

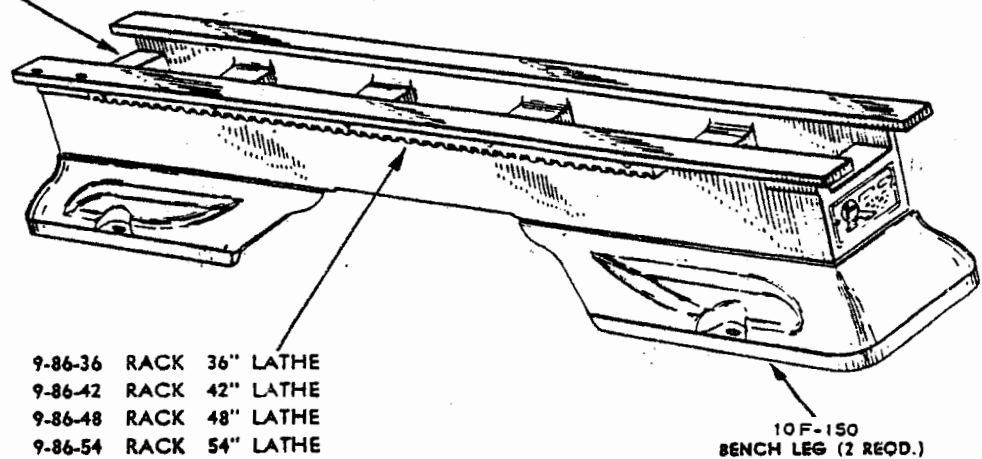
TAILSTOCK AND LATHE BED PARTS



10D-5X TAILSTOCK ASSEMBLY

942 B 42" LATHE BED ONLY

954 B 54" LATHE BED ONLY



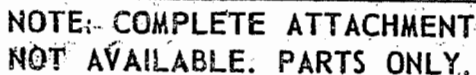
BED, LEGS, AND RACK ASSEMBLY

942BX 42" MODEL LATHE

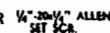
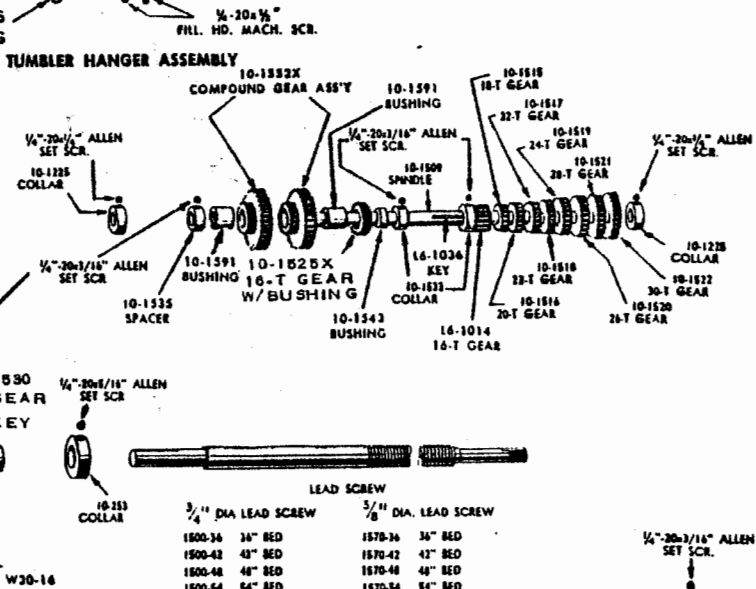
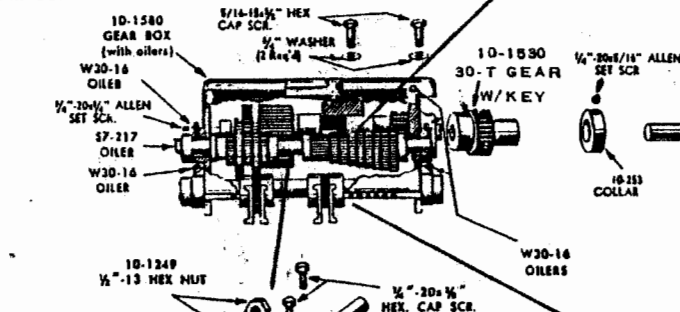
954BX 54" MODEL LATHE



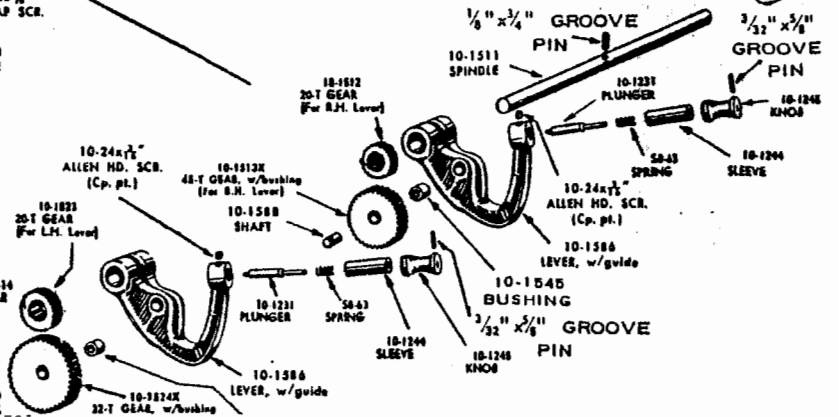
REPAIR PARTS FOR ATLAS Nos. 1500 and 1570 QUICK-CHANGE ATTACHMENT



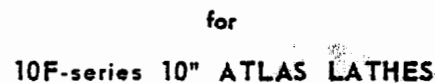
10-1273
TEMPLET
Used with 1/2" dia. band
screw lathe and



NOTE: COMPLETE ATTACHMENT
NOT AVAILABLE. PARTS ONLY.



THREADING CHART



with 3/4" diameter lead screw

FILE NO. 10-99A

FIG. 1

SPINDLE

64

32

20

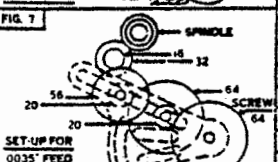
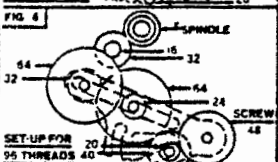
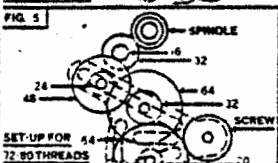
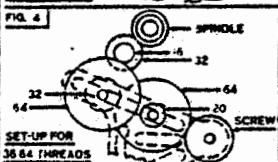
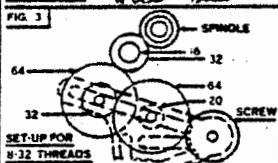
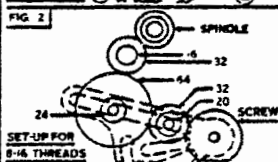
64

32

SCREW

SET-UP FOR
4-7 THREADS

A-B-C-D ARE GEAR STUD POSITIONS
B = BACK POSITION (TOWARD HEADSTOCK)
F = FRONT POSITION (AWAY FROM HEADSTOCK)
I = IDLER GEAR S = SPACER — = BLANK
X = 24 TOOTH GEAR IN BACK POSITION (SS) = DOUBLE KEYWAY SPACER

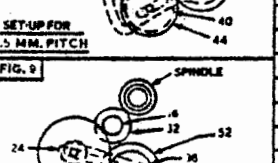
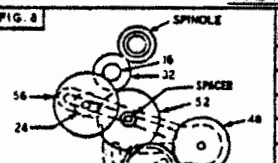


THREADS PER INCH	SCREW	POSITION D		POSITION F		POSITION G		POSITION H		POSITION A		SPINDLE STUD GEAR	FIG.
		8	F	8	F	8	F	8	F	8	F		
4	32F	—	—	—	—	—	—	24	48I64I	20SI	32	1	
4.5	36F	—	—	—	—	—	—	32	64I64I	20SI	32	1	
5	40F	—	—	—	—	—	—	32	64I64I	20SI	32	1	
5.5	44F	—	—	—	—	—	—	32	64I64I	20SI	32	1	
6	48F	—	—	—	—	—	—	32	64I64I	20SI	32	1	
6.5	52F	—	—	—	—	—	—	32	64I64I	20SI	32	1	
7	56F	—	—	—	—	—	—	32	64I64I	20SI	32	1	
8	32B	—	—	—	—	—	—	48I	20SI46I	24SI	32	2	
9	36B	—	—	—	—	—	—	32I	20SI54I	24SI	32	2	
10	40B	—	—	—	—	—	—	32I	20SI64I	24SI	32	2	
11	44B	—	—	—	—	—	—	32I	20SI64I	24SI	32	2	
11.5	46B	—	—	—	—	—	—	32I	20SI64I	24SI	32	2	
12	48B	—	—	—	—	—	—	32I	20SI64I	24SI	32	2	
13	52B	—	—	—	—	—	—	32I	20SI64I	24SI	32	2	
14	56B	—	—	—	—	—	—	32I	20SI64I	24SI	32	2	
16	64B	—	—	—	—	—	—	32I	20SI64I	24SI	32	2	
18	36F	—	—	—	—	—	—	20S	64I164	32I	32	3	
20	40F	—	—	—	—	—	—	20S	64I164	32I	32	3	
22	44F	—	—	—	—	—	—	20S	64I164	32I	32	3	
23	46F	—	—	—	—	—	—	20S	64I164	32I	32	3	
24	48F	—	—	—	—	—	—	20S	64I164	32I	32	3	
26	52F	—	—	—	—	—	—	20S	64I164	32I	32	3	
27	54F	—	—	—	—	—	—	20S	64I164	32I	32	3	
28	56F	—	—	—	—	—	—	20S	64I164	32I	32	3	
32	64F	—	—	—	—	—	—	20S	56I148	24I	32	3	
36	36B	—	—	—	—	—	—	64I	20SI24	48I	16	4	
40	40B	—	—	—	—	—	—	64I	20SI32	64I	16	4	
44	44B	—	—	—	—	—	—	64I	20SI32	64I	16	4	
48	48B	—	—	—	—	—	—	64I	20SI32	64I	16	4	
56	56B	—	—	—	—	—	—	64I	20SI32	64I	16	4	
64	64B	—	—	—	—	—	—	64I	20SI24	48I	16	4	
72	36F	20S	64I	—	—	—	—	64	32I24	48I	16	5	
80	40F	20S	64I	—	—	—	—	64	32I24	48I	16	5	
96	48F	40	20I	—	—	—	—	64I	24SI32	64I	16	6	

FEED PER REVOLUTION OF SPINDLE

FEED	SCREW	POSITION D	POSITION C	POSITION B	POSITION A	STUD	FIG.
.0018 77	64 B	—	20 64	52 20	24 48	16	—
.0035	64 F	—	—	64 20	20 56	16	7
.005	64 F X	52 20	—	54I (SS)	20 48	16	—
.006	64 F	52 20	—	54I (SS)	24 48	16	—
.007	64 B	—	—	20 64	56 20	32	—
.0087	64 F	56 20	—	36 46	20S 64I	16	—

METRIC THREADING CHART



PITCH IN MILLIMETERS	GEAR ON SCREW	POSITION D S F	POSITION C S F	POSITION B S F	POSITION A S F	SPINDLE STUD GEAR	FRE
.5	48F	40 44	— —	52I 33	24 56	16	8
.75	64F	40 32	— —	52 44	20S 56I	16	—
1.00	44F	40 32	— —	52 48	20S 64I	16	—
1.25	44B	— —	— —	52 48	20S 64I	16	—
1.50	44B	— —	— —	52 40	20S 64I	16	—
1.75	44F	48 52	— —	56 40	20S 64I	16	—
2.00	40F	44 48	— —	52 36	20S 64I	16	—
2.5	44B	— —	— —	52 24	20S 64I	16	—
3.0	44B	— —	— —	52 20	24S 64I	16	—
3.5	44F	48 56	— —	52 20	24S 64I	16	—
4.0	20F	44 48	— —	52 36	24S 64I	16	9
4.5	20F	44 54	— —	52 36	20S 64I	16	—
5.0	24F	44 52	— —	40 20	20S 64I	16	—
5.5	20F	— —	— —	48 52	64I 24S	32	—
6.0	20F	44 52	— —	48 24	32S 64I	16	—
7.0	48B	52 44	— —	20 56	64I 24S	32	—